

Date: Tuesday, 4/17/2007 11:02:34 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SA 315B LAMA SKID ASSY RH
Job Number : 31821	
Estimate Number : 12828	
P.O. Number : <i>N/A</i>	Part Number : D315668012
This Issue : 4/17/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2904 REV <i>XB</i>
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : <i>XB</i>
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/30/2007
Checked & Approved By : <i>[Signature]</i> 07.04.17	Qty: 1 Um: Each
Comment : Est Rev: A New Issue 07-04-12 JLM	

Additional Product

Job Number:



Seq:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD315-668-012

CHG 001

KJ 07.04.20 ①

2.0

D2904B

315 Skidtube Ext. (Bent)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

315 Skidtube Ext. (Bent)

Batch: *B31826*

3.0

D2910

Doubler (Lama skid)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Doubler (Lama skid)

BATCH: *B31827*

4.0

D2911

Doubler (Lama Skid)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Doubler (Lama Skid)

BATCH: *B31828*

5.0

D2912

Doubler (Lama Skid)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Doubler (Lama Skid)

BATCH: *B31829*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D315668012

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill aft cap hole as per Dwg D2904 using DT8025.

2-Drill saddle holes (6 Deg) as per Dwg D2904 & DT8938A.
(ENSURE THAT LOCATOR RING IS SET FOR RH TUBE)3-Drill Ghw Holes (3 Deg) as per Dwg D2904 using DT8938B
(ENSURE THAT LOCATOR RING IS SET FOR RH TUBE)

4-Insert doublers using DT8938C (Boone Apparatus)

5-Cleco Doublers and DT8938D in position. Transfer all 256 holes thru tube and Doublers.

6-Remove and Deburr doublers and Attach to work order.

7-C'sink Rivet holes 256 places as per Dwg D2904.

8-Deburr if nessary.

DP
7-4-25

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat *****Tube & Doublers *****as per QSI 005 4.1

DP 7-4-25

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

MS20601AD4W3

Rivet



Comment: Qty.: 256.0000 Each(s)/Unit Total: 256.0000 Each(s)

Rivet

BATCH:

M13282/H8325

DP 7-4-25

344

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 31821

Part Number: D315668012

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

D2905

Web (Lama)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web (Lama)

Batch: B31065

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Doublers as per Dwg D2904.

2-Open X-Bolt Spacer as per Dwg D2904
(Do not use Cutting oil)

3-C'Sink X-bolt spacer holes to prepare for Welding.

4-Remove indexing ridge from aft end of tube

5-Blow all chips from inside tube.

6-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch
A/R Sikaflex-291 M103561

Sikaflex expire date: 07-10-01

Start Time: 1:40 Date: 7-4-25

Fin Time: 1:00 Date: 7-05-07

13.0

D2909

Spacer (Lama)



Comment: Qty.: 11.0000 Each(s)/Unit Total: 11.0000 Each(s)

Spacer (Lama)

Batch: B14091 BE 0705-07

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld crossbolt spacers D2909as per Dwg. D2904and QSI 004.

For D2579 spacers, weld one side, pass Y" drill, weld other side, pass Y" drill

A/R Aluminum Rod

M102421 BE 0705-07
DP 7-5-7

4-Grind welds as per Dwg D2909 Grind

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 31821

Part Number: D315668012

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Cut Tube as per Dwg D2904.

7-Remove Indexing Ridge on Fwd End of tube as per Dwg D2904.

8-Drill Fwd Cap holes as per Dwg D2904 Using Dt 8025.

9-Deburr.

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/08

16.0

POWDER COATING

POWDER COATING



M103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

41

07-05-09

①

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2904 and QSI 005 4.4

Batch:

N/A see step 28.0

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.A. 07/05/09 ①

19.0

D2646

Aft Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Aft Cap

Batch:

B30119

20.0

D26483

Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Wearpad

Batch:

B29777

M.A. 07/05/09 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 31821

Part Number: D315668012

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D26483

Wearpad

REF D519172, D2648-5 REPLACED
BY D2648-3

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

4/17/07

Wearpad

Batch:

B29777

22.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch:

B29976

23.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch:

B21148

24.0

D2907

Wearshoe (Lama)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe (Lama)

Batch:

B14654

25.0

ALS41032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch:

M102475

26.0

AN960JD10L

Washer



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Washer

Batch:

M102832

27.0

MS27039108

Screw



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Screw

M103641

M-L
07/05/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 8/10/5/11

QA: N/C Closed: _____ Date: _____

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Job Number: 31821

Part Number: D315668012

Job Number:



Seq. #:

Machine Or Operation:

Description:

28.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2904. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

M103561

Sikaflex expire date: 07-10

3-Inspect for foreign object per QSI 024

4-Install 2646 Aft & fwd Caps as per Dwg D2904 and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

M103561

Sikaflex expire date: 07-10

5-Wing Walk as per Dwg D2904 and QSI 005 4.4

m103707

FL

Batch:

07/05/09 0

M-R
07/05/09

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/09 0

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D315-668-012

Location: _____

PPP Rev: _____

Rev A

7/5/9

SL

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/10

Job Completion



07/05/10

31821

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9172	REV. A SHEET 1 OF 1
DATE 99.11.02		TITLE WEARPAD KITS	SCALE NTS
A	99.11.02	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS: D206-642

IIN-D350-636

IIN-D058-672

IIN-D315-668

Qty -105	Qty -205	Qty -107	Qty -207	Part Number	Description
X				DSI 9172-105	SURFACITE™ WEARPAD KIT
	X			DSI 9172-205	STD. TUNGSTEN CARBIDE WEARPAD KIT
		X		DSI 9172-107	SURFACITE™ WEARPAD KIT
			X	DSI 9172-207	STD. TUNGSTEN CARBIDE WEARPAD KIT
	5		7	D2648-3	WEARPAD
5		7		D2648-7	WEARPAD
20	20	28	28	MS27039-1-08	SCREWS
20	20	28	28	AN960JD10L	WASHERS

NOTES:

- 1) D2648-5 CAN BE REPLACED BY D2648-3.
- 2) IN THE DSI 9172 -105/ -107 KTS, THE D2648-7 WEARPADS REPLACE THE D2648-3 AND D2648-5 WEARPADS SHOWN IN THE INSTALLATION INSTRUCTIONS.
- 3) THE ABOVE KITS CAN BE INSTALLED ON DART 206 A/B, 206L/L1/L3/L4, 407, OH-58 A/A+/C, AS 350/355, AND SA 315B SKIDTUBES ACCORDING TO THE FOLLOWING TABLE:

KIT	CAN BE INSTALLED ON
DSI 9172-105 DSI 9172-205	D206-642-111/ -112 D206-642-211/ -212/ -213/ -214 D350-636-011/ -012/ -013/ -014 D315-668-011/ -012 D058-672-011/ -012/ -013/ -014
DSI 9172-107 DSI 9172-207	D206-642-311/ -312 D206-642-411/ -412

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WORK ORDER
NO. 31821

- 4) INSTALLATION OF THE DSI 9172 -105 KIT WILL ADD 0.95 lbs (0.43 kg) TO THE WEIGHT OF THE SKIDTUBE.
- 5) INSTALLATION OF THE DSI 9172 -107 KIT WILL ADD 1.33 lbs (0.60 kg) TO THE WEIGHT OF THE SKIDTUBE.



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2904	Rev. B SHEET 1 OF 3
DATE 00.06.21		TITLE SA 315B SKIDTUBE ASSEMBLY	SCALE NTS
A	99.09.09	NEW ISSUE	
B	00.06.21	CHANGED ANGLES FOR HOLES	

PARTS LIST:

Qty -041	Qty -042	Part Number	Description
X		D2904-041	LH SKIDTUBE ASSEMBLY
	X	D2904-042	RH SKIDTUBE ASSEMBLY
2	2	D2646	CAP
4	4	D2648-3	WEARPAD
1	1	D2648-5	WEARPAD
1	1	D2656-13	WEARSHOE
1	1	D2656-33	WEARSHOE
1		D2904-1	SKIDTUBE
	1	D2904-2	SKIDTUBE
1	1	D2905	WEB
1	1	D2907	WEARSHOE
11	11	D2909	CROSS BOLT SPACER
2	2	D2910	SKIDTUBE DOUBLER
2	2	D2911	SKIDTUBE DOUBLER
2	2	D2912	SKIDTUBE DOUBLER
50	50	ALS7-1032-130 or AKS4-1032-130 or ALS4-1032-130 or ALS7-1032-130	INSERT
54	54	AN960JD10L	WASHER
256	256	MS20601AD4W3	RIVET
54	54	MS27039-1-08	SCREW

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RELEASED
00.09.01 #

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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2904	Rev. B SHEET 2 OF 3
DATE 00.06.21		TITLE SA 315B SKIDTUBE ASSEMBLY SCALE 1:20	

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE D2904-1 AND D2904-2 FROM D2914 EXTRUSION (INITIAL LENGTH = 142.0).
3. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTION C-C.
5. DRILL #30 HOLES ($\varnothing 0.128$ REF) TO LINE UP WITH $\varnothing 0.128$ HOLES IN D2910/D2911/D2912 DOUBLERS. C'SINK $\varnothing 0.239 \times 100^\circ$.
6. BOND D2905 WEB INTO D2904-1 (OR D2904-2) OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
7. WELDING TO BE DONE PER DART QSI 004.
8. AFTER DRILLING, BENDING, AND INSTALLING WEB & DOUBLERS, PERFORM THE FOLLOWING FOR $\varnothing 0.500$ HOLES ONLY:
 - CHAMFER HOLE $0.050 \times 45^\circ$
 - INSERT D2909 SPACER (11 PLACES)
 - WELD INTO PLACE
 - GRIND FLUSH
 - DRILL OUT SPACER TO $\varnothing 0.406$
9. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 - MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 - MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
10. FINISH:
 - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2905 WEB AND D2910/D2911/D2912 DOUBLERS.
 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 - BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
11. DRILL $\varnothing 0.297$ FOR ALS7-1032-130 INSERT USING DT8395 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH.

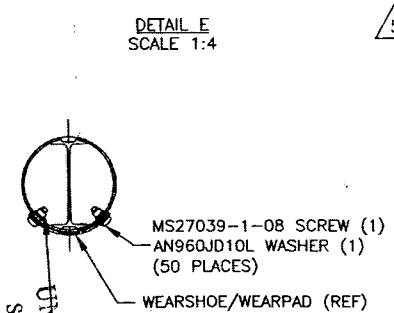
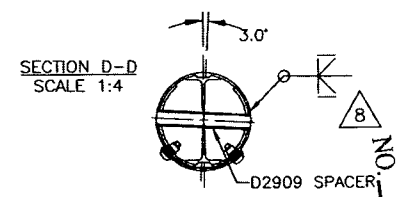
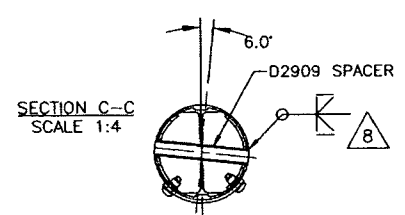
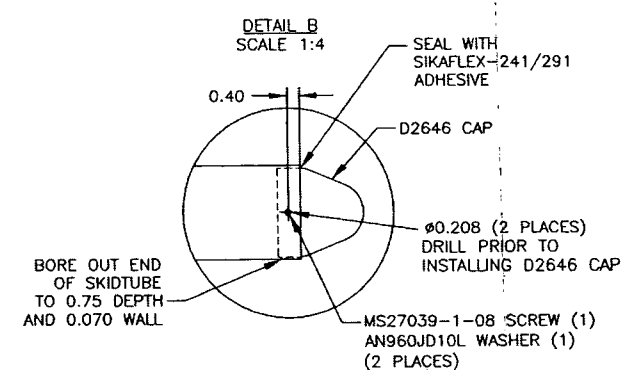
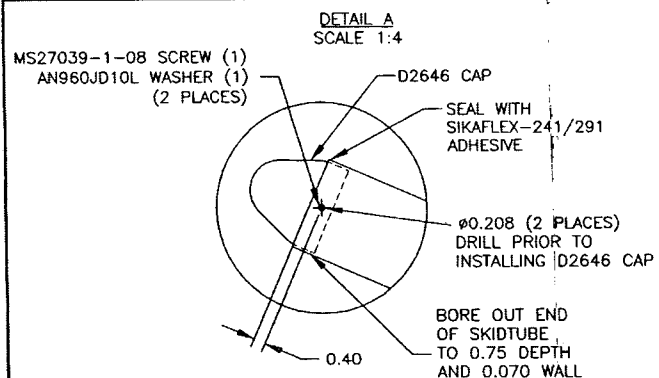
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NO. 31821

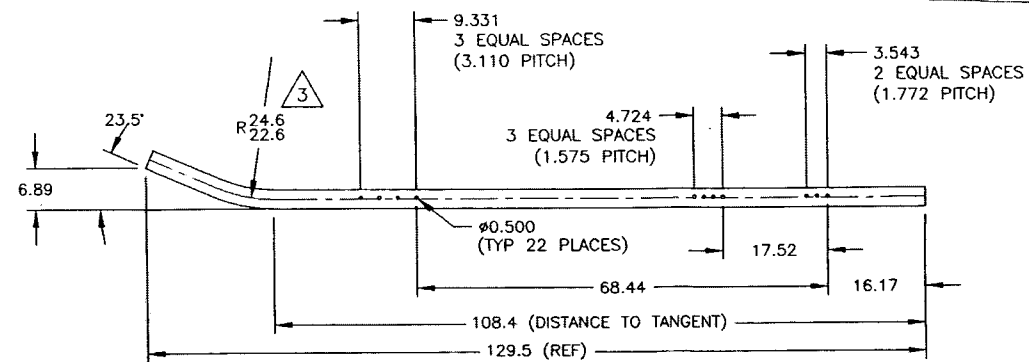
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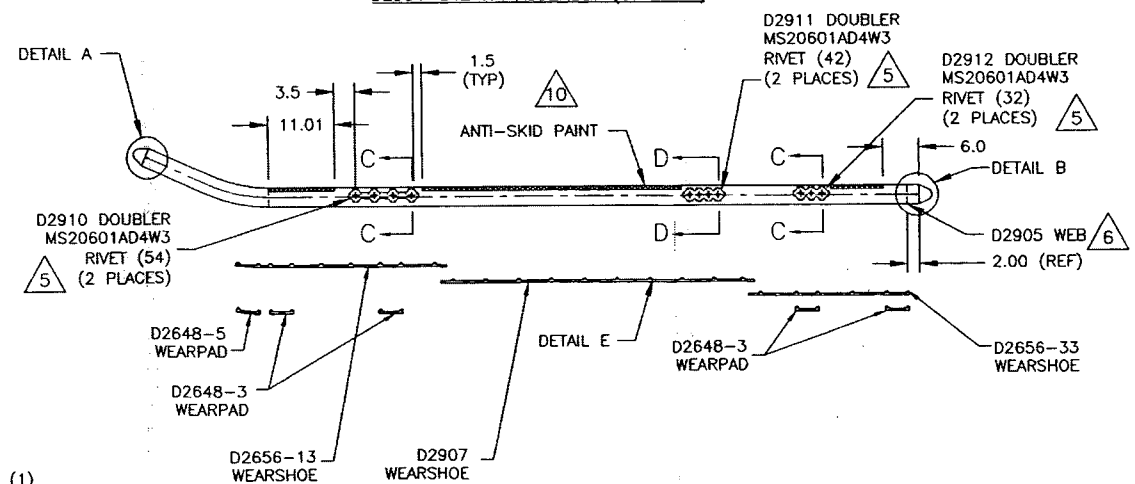
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06.04.01



D2904-1 BENDING/DRILLING DETAIL (SHOWN)
D2904-2 BENDING/DRILLING DETAIL (OPPOSITE)



D2904-041 LH ASSEMBLY DETAIL (SHOWN)
D2904-042 RH ASSEMBLY (OPPOSITE)



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		DATE	00.06.21	TITLE		SA 315B SKIDTUBE ASSEMBLY	
						SCALE 1:20	

NO WORK ORDER
31821
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ALST-1032-130 INSERT (1)

NO. 108

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A 315688012 / B 31821

TEST WELDS REQUIRED

BASE METAL Alum

WELDING PROCESS Tig

Penetration Complete ☐ Partial ☒

Single Weld ☒ Double Weld ☐

Current AC ☒ DC ☐

Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into

Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐

Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/05/08 Qualifier David Rued